

Work Order ID 134397

Wednesday, July 08, 2015 3:12:42 PM

134397

Page 1

Item ID: D3368-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tail Rotor Pedal Lock
 Start Date: 7/14/15 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 7/18/15 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: JUL 09 2015 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2690	B2								
D3368	B								
D3384	C								

100

0.00

100

Small Fab

Small Fab

Memo

0.03

Small Fab

1-Open D3373-7 lock package. Keep keys, lock body, lock body nut, screw, flat cam and lock barrel. Discard the rest.

2-Fabricate D3371-5 Cam Lock as per Dwg D3371

3- Cut cable to length as per dwg D2690 and D3384

4- Assemble lanyard to cyclic sock as per Dwg D3384
 Identify as D3384-047

Identify as D3371-53-Assemble lock mechanism and cam and install decal as per Dwg D3368.

NOV-30 2015

PTO

DQA:

Date: 2017.05.25



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: MAY 16 2017

Work Order update only ☐

Work Order: <u>134397</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. <u>D3363-041</u>		Rework ☒		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. <u>17-6419</u>		Scrap ☐		Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			
Date: <u>DEC03/16</u>		Step #: <u>100</u>		QTY Effective: <u>(2)</u>			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition			68-6 22 SVC 15.12.03		
D 3385-3 don't fit properly. on the past had to make Hinge with MS 20257C.720				Fabricate Make 2 Hinge MS 20257C.720 11/20/246			Completed By DAS 30 9-89 DEC 03 2015		
							Lead hand / Supervisor Approval Verification DAS 30 9-89 DEC 03 2015		
							QC / QA Coordinator Approval DAS 9 9-89 16-12-09		
Root-Cause ✓ Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Set-up ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☒ Misidentified ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☒ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☐ Heat Treat ☐ Cut Too Short ☐ Misaligned/off center ☐ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☐ Misaligned/off center ☐ Turning Sequence ☐					
OTHER: <u>Fabricate Hinge</u>									

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N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

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2

Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

DAS
38

NOV 30 2015

120

Identify as per dwg & Stock Location: _____

0.00

120

Packaging

Memo

0.00

Packaging

DAS

6

9-09

DEC 03 2015

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

15/12/13

SHA
20151203

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Parent Item: D3368-041

D3368-041

Parent Item Name: Tail Rotor Pedal Lock

Start Date: 7/14/15

Required Date: 7/18/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A Removed from 9 Digit 06-03-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

238-028		Purchased	No			100	Each	87.0000	2	4			
---------	--	-----------	----	--	--	-----	------	---------	---	---	--	--	--

238-028

3/16" Dowel Pin .5" long

Location	Loc Qty	Loc Code
----------	---------	----------

ST568	87	
-------	----	--

M132062	87	
---------	----	--

385-039		Purchased	No			100	Each	84.0000	4	8			
---------	--	-----------	----	--	--	-----	------	---------	---	---	--	--	--

385-039

8-32 Flat screw

Location	Loc Qty	Loc Code
----------	---------	----------

ST570	84	
-------	----	--

M130688	84	
---------	----	--

CBL-1240		Purchased	No			100	f	552.0772	2.3333	5			
----------	--	-----------	----	--	--	-----	---	----------	--------	---	--	--	--

CBL-1240

Cable

Location	Loc Qty	Loc Code
----------	---------	----------

GA	552.0772	
----	----------	--

m130006	52.0772	
---------	---------	--

m132518	500	
---------	-----	--

CBL-460		Purchased	No			100	Each	250.0000	2	4			
---------	--	-----------	----	--	--	-----	------	----------	---	---	--	--	--

CBL-460

Loop Sleeve

Location	Loc Qty	Loc Code
----------	---------	----------

GA	250	
----	-----	--

m131619	250	
---------	-----	--

DAC

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NOV 25 2015

NOV 30 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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Parent Item Name: Tail Rotor Pedal Lock

Start Date: 7/14/15

Required Date: 7/18/15

Start Qty: 2.00

Required Qty: 2.00

D3368-1 Manufactured No

100 Each 1.0000 1 2

**

134401 SD

D3368-1

Pedal Lock Base

Location

Loc Qty

Loc Code

ST496

1

115046

1

D3368-3 Manufactured No

100 Each 0.0000 1 2

**

12/33/18

D3368-3

Pedal Lock Cover

D3373-7 Manufactured No

100 Each 13.0000 1 2

**

1XB134366 cy

D3373-7

Cam Lock

Location

Loc Qty

Loc Code

ST036

13

123528

2

94791

11

D3384-1 Manufactured No

100 Each 7.0000 1 2

**

134274

D3384-1

Cyclic Sock

Location

Loc Qty

Loc Code

ST500

7

123313

1

133088

6

D3385-3 Manufactured No

100 Each 26.0000 1 2

**

FF NOV 30 2015

D3385-3

Hinge

Location

Loc Qty

Loc Code

ST036

26

117534

26

*MS20251cy.7200

Wednesday, July 08, 2015 3:12:42 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Page 3

Wednesday, July 08, 2015 3:12:42 PM

Work Order ID: 134397

134397

Parent Item: D3368-041

D3368-041

Parent Item Name: Tail Rotor Pedal Lock

Start Date: 7/14/15

Required Date: 7/18/15

Start Qty: 2.00

Required Qty: 2.00

HX-81 Purchased No 100 Each 64.0000 1 2

HX-81

1/4"-20 SHCS 3/8" long

Location

Loc Qty

Loc Code

ST554

64

123436

64

NAS1149F0463P

Purchased

No

100

Each

1,248.000

2

4

NAS1149F0463P

Washer

Location

Loc Qty

Loc Code

ST260a

977

m127832

977

st268

271

m127832

247

m130388

24

NOV 25 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

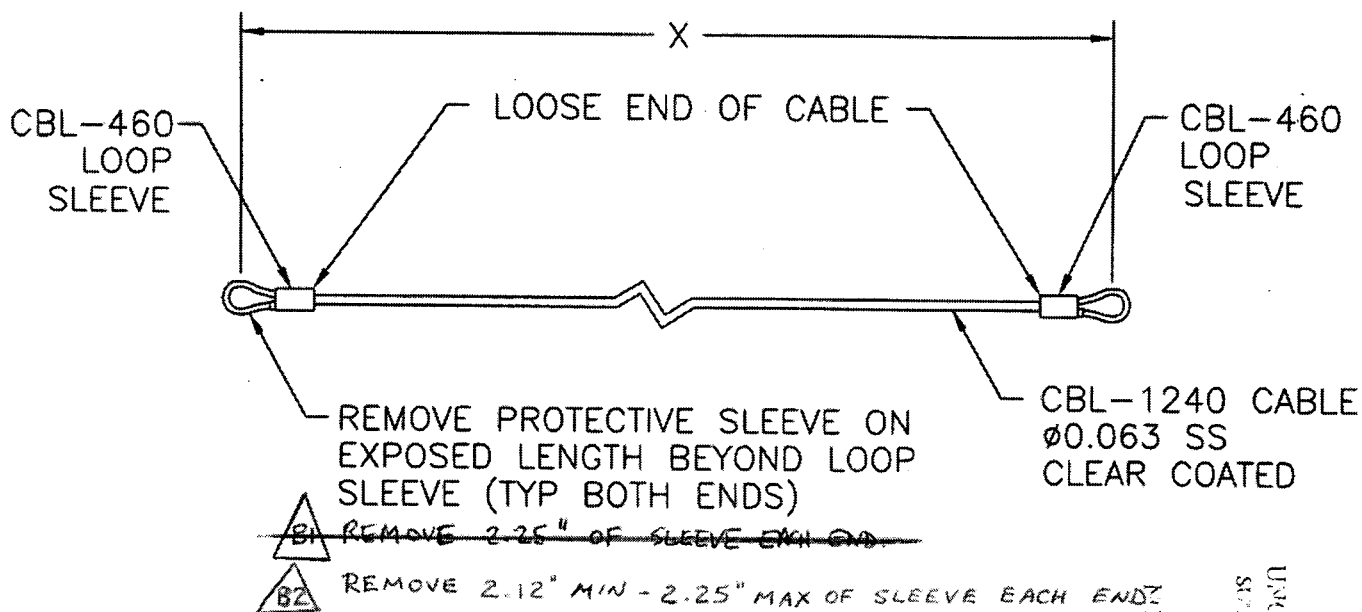
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
				Lead hand / Supervisor Approval Verification																	
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Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER : _____																					



DESIGN <i>ME</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>ME</i>	APPROVED <i>BW</i>	DRAWING NO. D2690	REV. B SHEET 1 OF 1
DATE 97.10.02		TITLE LANYARD ASSEMBLY	SCALE NTS
A	97.07.03	NEW ISSUE	
B	97.10.02	REVISED NOTE FOR ADDITIONAL LENGTH	
B1	CP 01.08.20	ADD NOTE TO REMOVE 2.25" OF SLEEVE	
B2	CP 04.06.24	ADDED TOLERANCE	

RELEASED
971003 KE
TSR A374



D2690-X

X = LENGTH IN INCHES

NOTE: CUT CABLE 2.50* INCHES LONGER THAN 'X' LENGTH. FOLD ENDS TIGHT TO 'X' LENGTH AND CRIMP WITH SLEEVE AT END OF LOOSE END OF CABLE WITH CBL-705 CRIMPING TOOL.
*ADDITIONAL LENGTH MAY BE NECESSARY IN SOME APPLICATIONS. CUT AS REQUIRED.

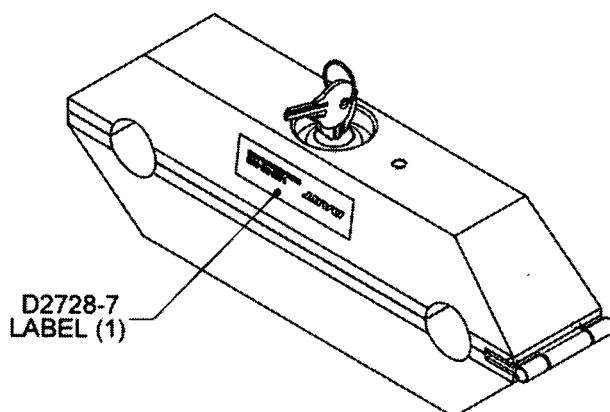
NOTE: IN SOME CASES, END HAS TO BE CRIMPED AFTER ASSEMBLY WITH ATTACHING PARTS.

SHOP COPY
ATTACHED
UNION IN COPY
SUBJECT TO COMMENT
134397 MJS
1807-09

DEO's

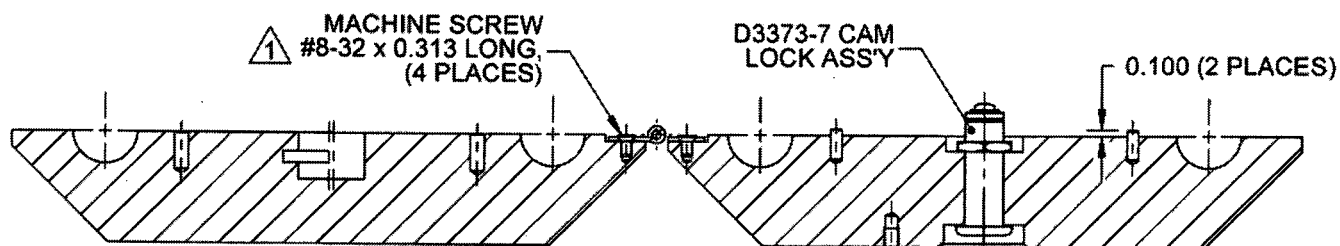


DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 13	APPROVED 13	DRAWING NO. D3368	REV. B SHEET 1 OF 3
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:3
A	05.01.19	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	

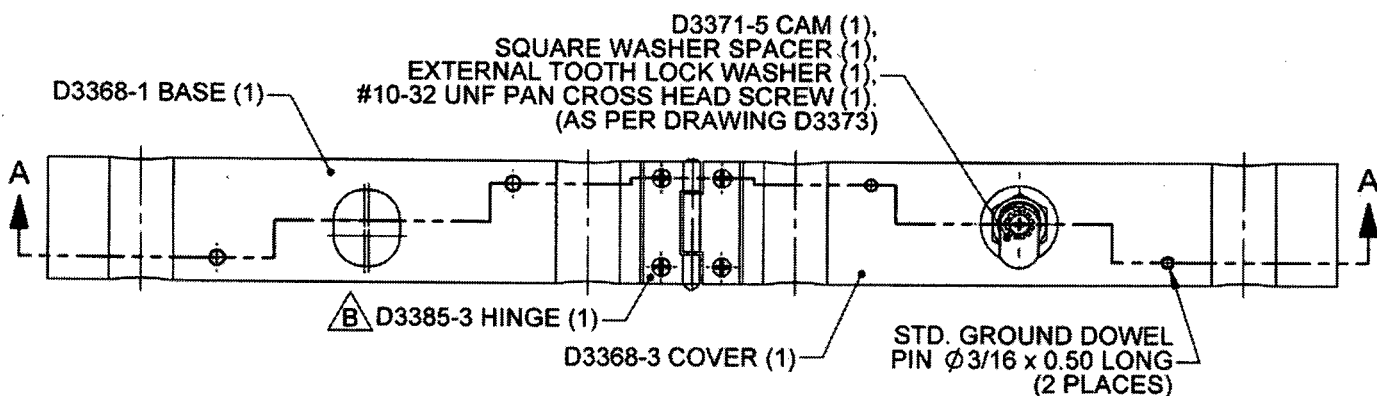


RELEASED
25/04/28

PEDAL LOCK SHOWN LOCKED WITH KEY



SECTION A-A



D3368-051 PEDAL LOCK ASSEMBLY

NOTES:

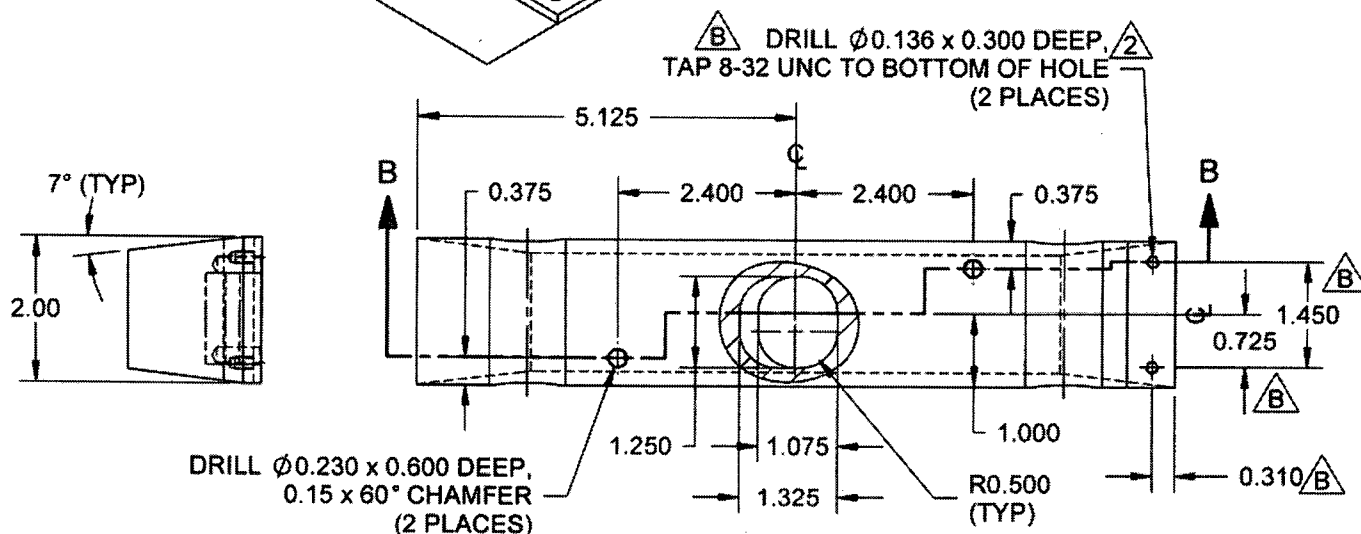
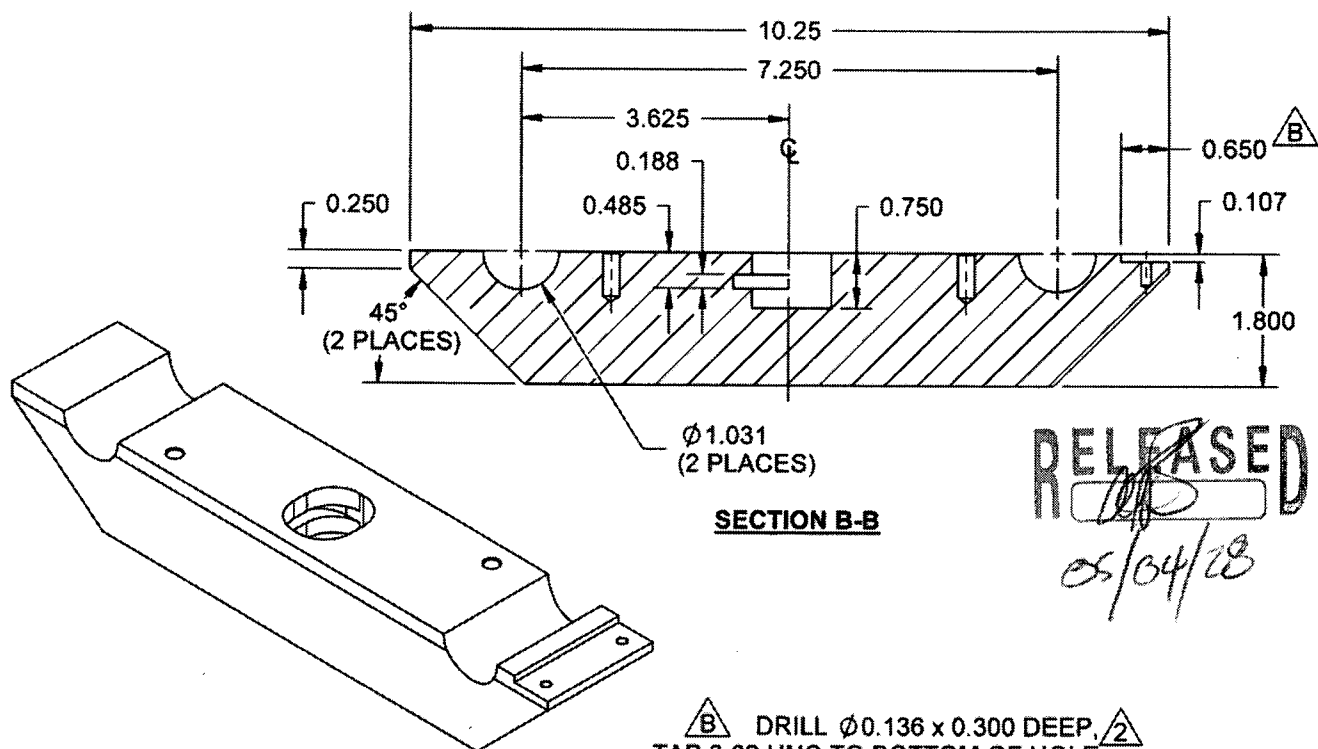
- 1) POSSIBLE SUPPLIER: SPAENAU P/N 385-044
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED [Signature]	DRAWING NO. D3368	REV. B SHEET 2 OF 3
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:2.5



D3368-1 BASE

NOTES:

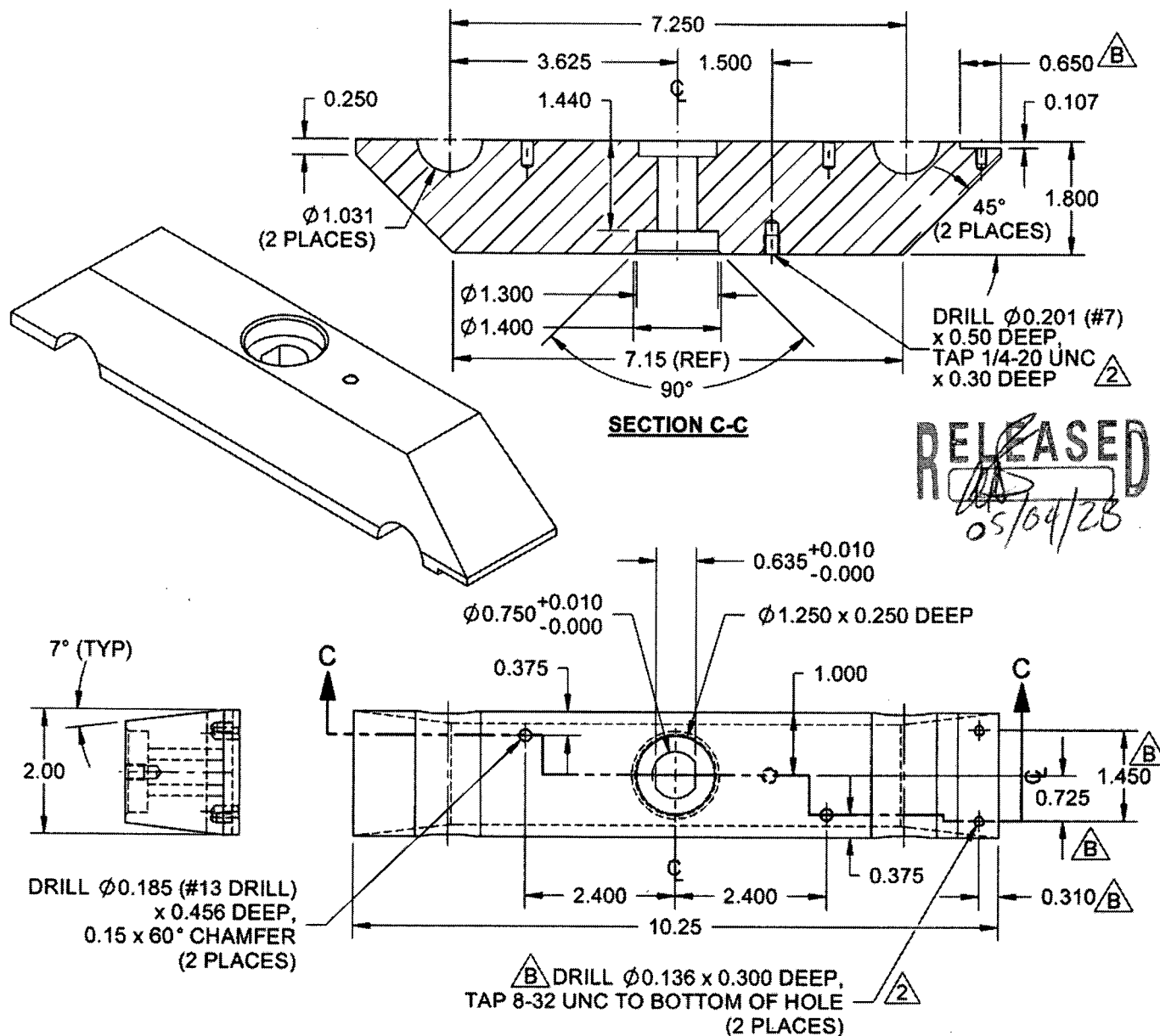
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3368	REV. B SHEET 3 OF 3
DATE 05.03.22	TITLE PEDAL LOCK		SCALE 1:2.5



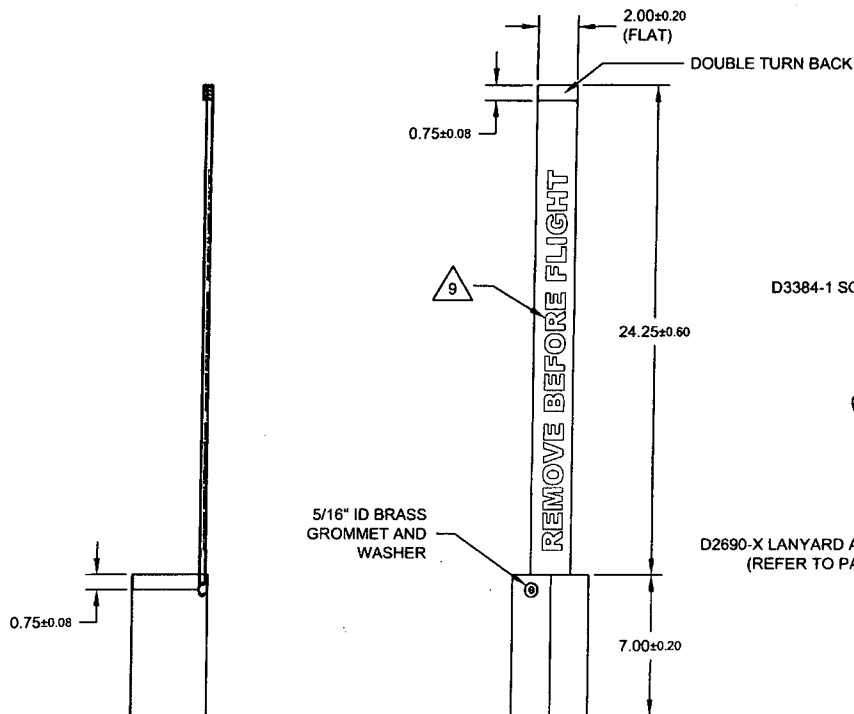
D3368-3 COVER

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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D3384-1 SOCK

D3384-1 SOCK

D2690-X LANYARD ASSEMBLY
(REFER TO PARTS LIST)

D3384-0XX SOCK ASSEMBLY

QTY	QTY	QTY	QTY	QTY	P/N	DESCRIPTION
-041	-043	-045	-047	-049		
X					D3384-041	SOCK ASSEMBLY
	X				D3384-043	SOCK ASSEMBLY
		X			D3384-045	SOCK ASSEMBLY
			X		D3384-047	SOCK ASSEMBLY
				X	D3384-049	SOCK ASSEMBLY
	1				D2690-8	LANYARD ASSEMBLY
		1			D2690-20	LANYARD ASSEMBLY
1					D2690-24	LANYARD ASSEMBLY
			1		D2690-28	LANYARD ASSEMBLY
				1	D2690-30	LANYARD ASSEMBLY
1	1	1	1	1	D3384-1	SOCK

D3384-1 NOTES:

- SUPPLIER: TULMAR P/N 8972
MATERIAL: 420 DENIER NYLON CLOTH, PVC COATED, COLOUR RED
- THREAD: STITCHING IAW D-6193 6 TO 10 STITCHES PER INCH USING V-T-295 RED NYLON THREAD, TY2, CL A, SIZE E
- FINISH: NONE
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: NONE
- WEIGHT: N/A
- STENCIL THE FOLLOWING: "REMOVE BEFORE FLIGHT" ON BOTH SIDES OF STRIP WITH 1" LETTERS USING WHITE INK AS PER SUPPLIER

RELEASED
2012-06-25

C	UPDATED NOTE 9. REASON: PAR12-204.	MB	12.06.25
B	CHG TOLERANCES DWG UPDATED ADD MATERIAL & SUPPLIER INFO	DC	07.11.23
A	NEW ISSUE	RF	05.01.20
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3384	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SOCK ASSEMBLY	NTS
DATE	12.06.25	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	